

## November 04, 2009 9:21:52 AM



**Accept**

**Setup Start**

B

Saddle LH

**Stop**

**Start Qty:** 10.00**Cust Item ID:****Req'd Qty: 10.00**

**Customer:**

**Reference:**

**Approvals:**

Process Plan: mf

Date: 09-11-04

**Tooling:**

**Date:**

Run Start



**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

**Stop**

[illegible]

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 53422

November 04, 2009 9:21:53 AM



Page 2

Item ID: D2917-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle LH

Start Date: 11/9/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/13/2009 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:10 AM OVEN TEMPERATURE:  
9:40 FINISH TIME: 320°F

09-11-19

10

09/11/19

X10

09/11/20

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 53422**

November 04, 2009 9:21:53 AM



Page 3

Item ID: D2917-1

Accept



Setup Start

Revision ID: B

Stop

Item Name: Saddle LH

Start Date: 11/9/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/13/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/11/20

X10

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

CE 9/11/20 (10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

H. 09-11-23

H 09-11-20 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 04, 2009 9:21:52 AM

Page 1

Work Order ID: 53422



Parent Item: D2917-1RevB



Parent Item Name: Saddle LH

Start Date: 11/9/2009

Required Date: 11/13/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	11.0000	10.0000			
Saddle Billet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	11	
51423	6	
52067	5	

Batch # 1353519      smf 09/11/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 53422
<b>Description:</b> Saddle LH	<b>Part Number:</b> D2917-1
<b>Inspection Dwg:</b> D2917 Rev. A1 <i>JB</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		.189	.189	.188	.187		
B	0.090	0.110		.090	.097	.100	.090		
C	0.250	0.270		.265	.267	.266	.265		
D	1.599	1.619		1.615	1.618	1.614	1.614		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.288	.284	.285	.286		
G	1.385	1.400		1.392	1.394	1.392	1.392		
H	3.170	3.230		3.209	3.210	3.206	3.209		
I	0.175	0.217		.183	.183	.185	.181		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.505	1.505	1.505	1.505		
L	4.436	4.446		4.441	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.260	.260	.258	.258		
N	1.225	1.235		1.230	1.230	1.230	1.230		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.442	.443	.443	.443		
R	0.490	0.510		.498	.505	.510	.506		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.200	.195	.195	.197		
W	1.990	2.010		2.007	2.009	2.008	2.006		
X	0.760	0.765		.763	.760	.760	.760		
Y	0.307	0.312		.311	.312	.312	.311		
Z	0.615	0.635		.624	.623	.624	.623		
AA	0.177	0.197		.189	.188	.188	.189		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>BS</i>
Date: 09/11/15

Audited by: <i>[Signature]</i>
Date: 09.11.15

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 53422
<b>Description:</b> Saddle LH	<b>Part Number:</b> D2917-1
<b>Inspection Dwg:</b> D2917 Rev. A1B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	SA	LA	TA	PA	By	Date
A	0.175	0.205		.137	.133	.139	.139		
B	0.090	0.110		.100	.100	.100	.095		
C	0.250	0.270		.264	.265	.265	.264		
D	1.599	1.619		1.615	1.615	1.615	1.614		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.237	.239	.236	.235		
G	1.385	1.400		1.392	1.390	1.391	1.390		
H	3.170	3.230		2.210	3.210	3.007	3.210		
I	0.175	0.217		.184	.184	.180	.177		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.503	1.503	1.503	1.503		
L	4.436	4.446		4.440	4.440	4.440	4.440		
M	0.257	0.262	DT8683	.258	.259	.259	.259		
N	1.225	1.235		1.230	1.230	1.230	1.230		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.443	.443	.443	.441		
R	0.490	0.510		.500	.504	.500	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.195	.194	.195	.193		
W	1.990	2.010		2.006	2.005	2.004	2.005		
X	0.760	0.765		.760	.764	.764	.764		
Y	0.307	0.312		.311	.310	.310	.310		
Z	0.615	0.635		.623	.623	.623	.622		
AA	0.177	0.197		.189	.185	.187	.185		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>85</i>
Date: 09/11/16

Audited by: <i>[Signature]</i>
Date: 09.11.19

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 53402
<b>Description:</b> Saddle LH	<b>Part Number:</b> D2917-1
<b>Inspection Dwg:</b> D2917 Rev. A1 <i>AD</i>	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 X	10 X	3	4	By	Date
A	0.175	0.205		.184	.188				
B	0.090	0.110		.090	.090				
C	0.250	0.270		.265	.264				
D	1.599	1.619		1.615	1.613				
E	0.180	0.220		.180	.180				
F	0.277	0.297		.290	.287				
G	1.385	1.400		1.386	1.387				
H	3.170	3.230		3.210	3.210				
I	0.175	0.217		.175	.177				
J	0.470	0.530		.500	.506				
K	1.498	1.508		1.503	1.506				
L	4.436	4.446		4.440	4.440				
M	0.257	0.262	DT8683	.260	.260				
N	1.225	1.235		1.230	1.230				
O	1.103	1.113		1.107	1.105				
P	0.470	0.530		.500	.500				
Q	0.438	0.443	DT8682	.441	.441				
R	0.490	0.510		.503	.506				
S	1.745	1.755		1.750	1.750				
T	7.990	8.010		8.000	8.000				
U	3.495	3.505		3.500	3.500				
V	0.175	0.205		.193	.191				
W	1.990	2.010		2.000	2.001				
X	0.760	0.765		.763	.763				
Y	0.307	0.312		.310	.310				
Z	0.615	0.635		.622	.622				
AA	0.177	0.197		.188	.188				
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>BE</i>
Date: <i>09/11/16</i>

Audited by: <i>af</i>
Date: <i>09.11.19</i>

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>af</i>	<i>af</i>

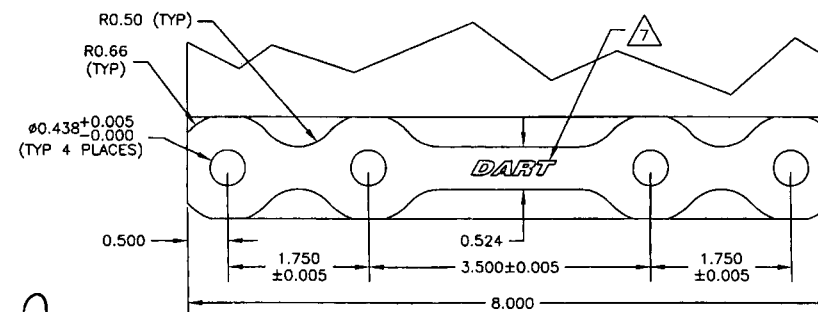
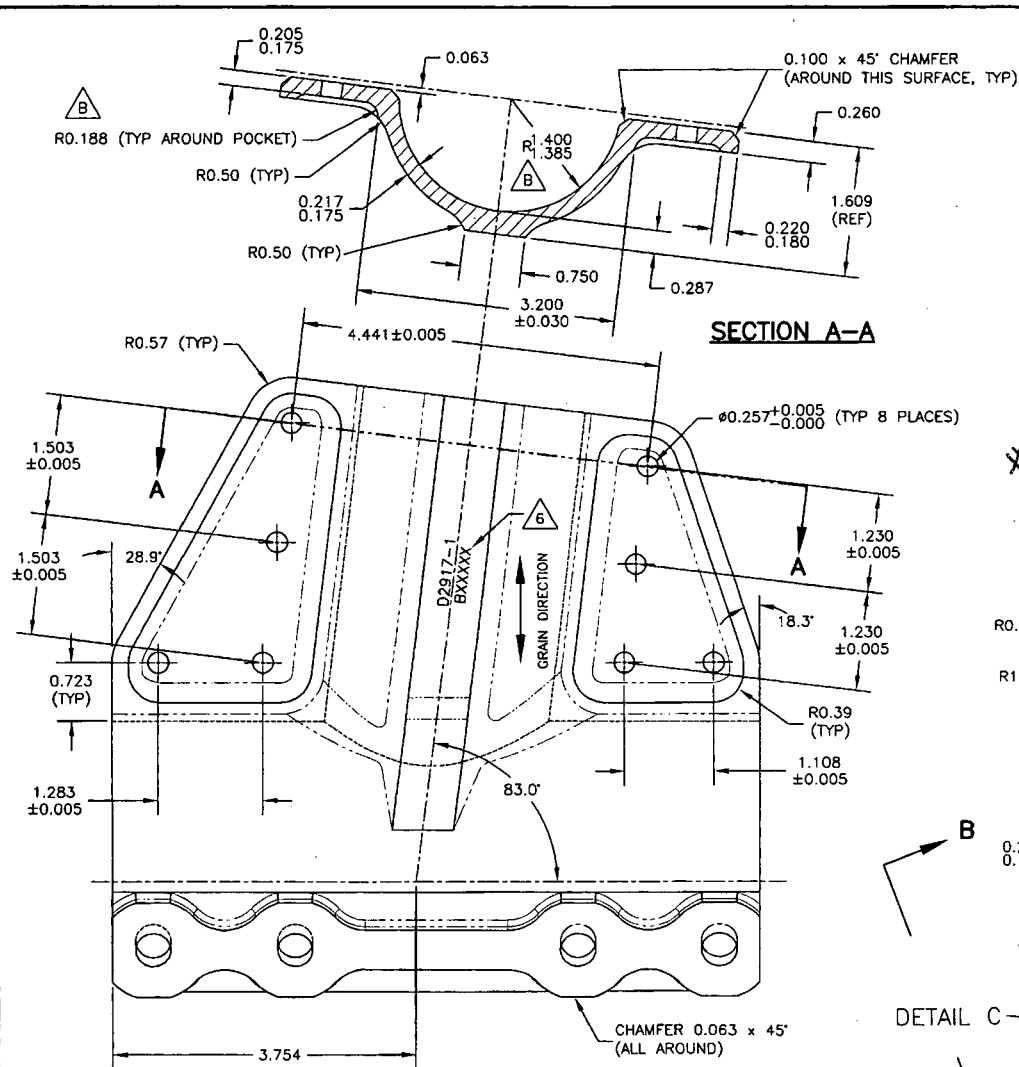
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

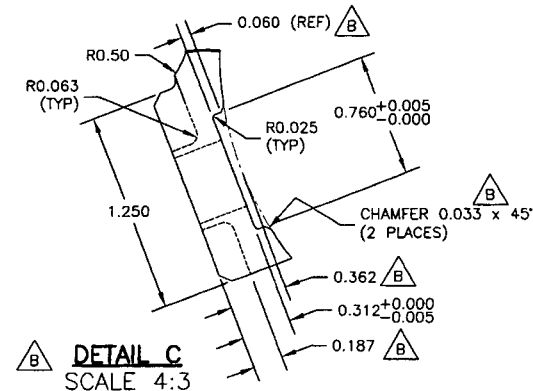
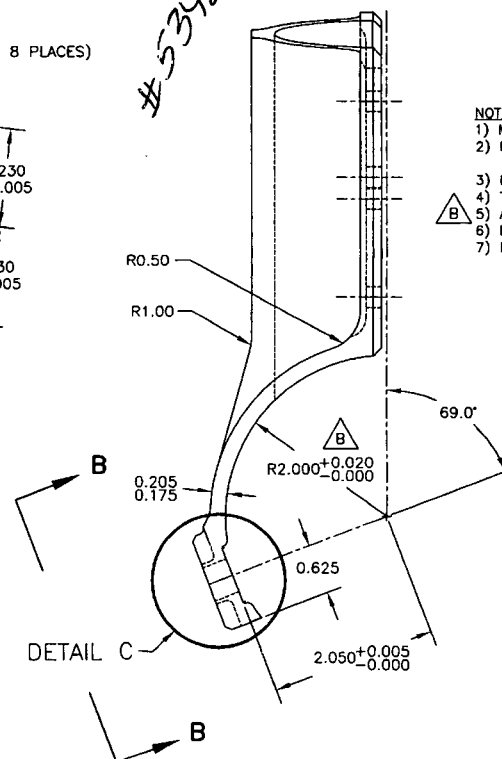
**NOTE:** Date & initial all entries



**D2917-1 LH SADDLE (SHOWN)**  
**D2917-2 RH SADDLE (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



**RELEASED**

07.07.31

B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	90	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE
		SADDLE
		DART
		DART AEROSPACE LTD.
		MARKESBURY, ONTARIO, CANADA
		DRAWING NO.
		D2917
		REV. B
		SHEET 1 OF 1
		SCALE
		2:3


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DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

**NOTE:** Date & initial all entries